

**Work Order ID 59195**

May 27, 2010 2:39:22 PM



Page 1

Item ID: D3779-3

Revision ID:

Item Name: Plate

Start Date: 5/27/10 Start Qty: 2.00

Accept



Setup Start



Required Date: 5/27/10 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3779	Rev A

100



FLOW WATER JET

Waterjet

## Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3779  Dwg Rev: A  Prog Rev: A  2-  
Deburr if necessary

HB10-5-27

O

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

0.00

0.00

0.00

S100128

+2

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Page 2

Item ID: D3779-3

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 5/27/10 Start Qty: 2.00



Cust Item ID:

Required Date: 5/27/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

(2)

BL 10-5-31

Hand Finishing

140



QC

QC3- Inspect Part Finish

0.00

M 10/05/31

28

Quality Control

150



Packaging

Identify as per dwg & Stock Location: 87

0.00

10-5-31 (2) 87

Packaging

**Work Order ID 59195**

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Item ID: D3779-3

Accept



Setup

Start



Revision ID:

Item Name: Plate

Stop



Start Date: 5/27/10 Start Qty: 2.00



Cust Item ID:

Required Date: 5/27/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/01 AD

M 10-6-01  
(2)

# Picklist Print

May 27, 2010 2:39:21 PM

Page 1

Work Order ID: 59195



Parent Item: D3779-3



Parent Item Name: Plate

Start Date: 5/27/10

Required Date: 5/27/10

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased		No		100	sf	39.5000	0.1937	0.407789			1810-5-37

6061-T6 .050 Sheet

Location	Loc Qty	Loc Code
MAT21	39.5	
110791	4.5	
113216	32	113216
17349	3	

(2)

DART AEROSPACE LTD	Work Order:	5998
Description: Plate	Part Number:	D3779-3
Inspection Dwg: D3779	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

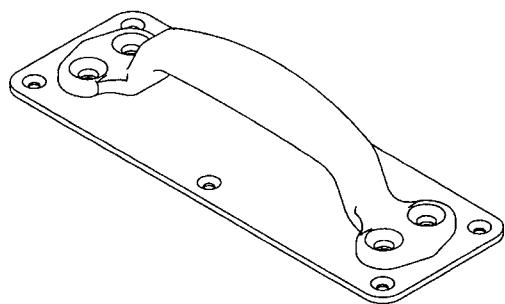
Measured by:	<u>AB</u>	Audited by:	<u>C</u>	Prototype Approval:	N/A
Date:	10-5-27	Date:	10/05/28	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	08.08.01	New Issue	KJ/DD	

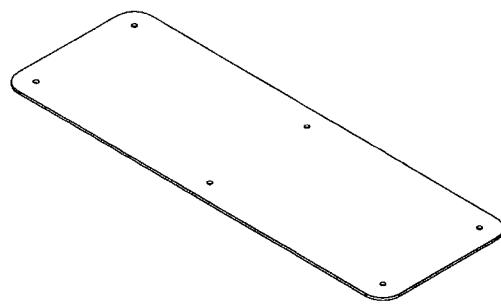
8 7 6 5 4 3 2 1

QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
1	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
4	4	MS20426AD10-8	RIVET, CSK

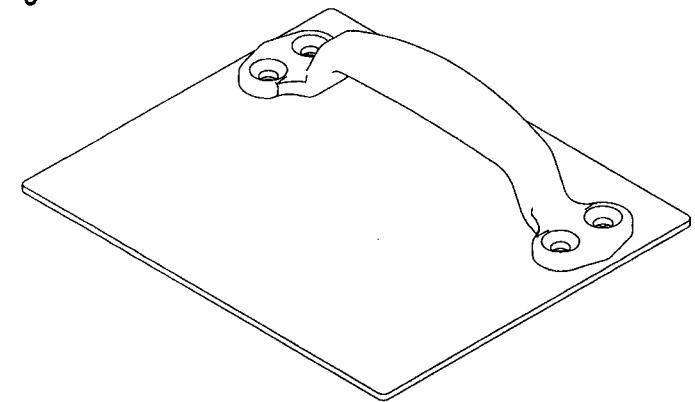
WHD 5995



D3779-041 HANDLE ASSEMBLY  
(EXTERIOR)



D3779-3 DOUBLER PLATE



D3779-043 HANDLE ASSEMBLY  
(INTERIOR)

RELEASED  
08.04.21

A	NEW ISSUE	AJS	08.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3779	SHEET 1 OF 4
APPROVED		TITLE HANDLE ASSEMBLY, CABIN SLIDING DOOR	
DE APPR.		SCALE	NTS
DATE	08.04.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR OTHERWISE DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

8

7

6

5

4

3

2

1

D

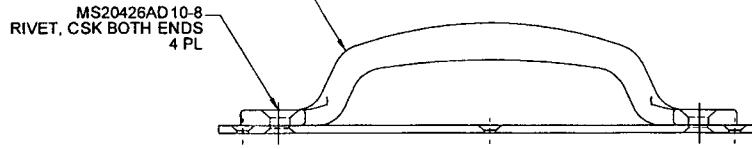
D

C

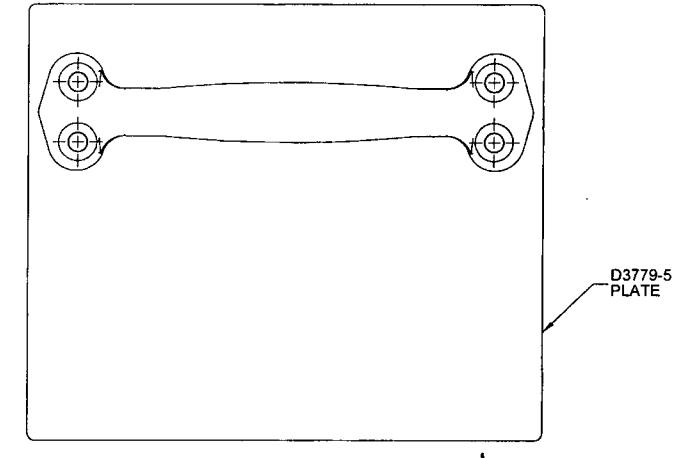
C

B

B



**D3779-041 HANDLE ASSEMBLY  
(EXTERIOR)**



**D3779-043 HANDLE ASSEMBLY  
(INTERIOR)**

**RELEASED**  
08-06-26 MR

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-041" USING FINE POINT PERMANENT INK MARKER
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-043" USING FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.71 lbs APPROX (-041)
- 9) WEIGHT: 1.14 lbs APPROX (-043)

8

7

6

5

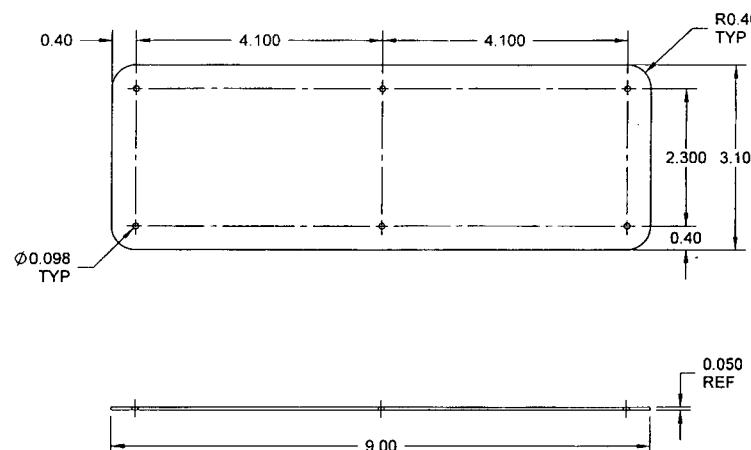
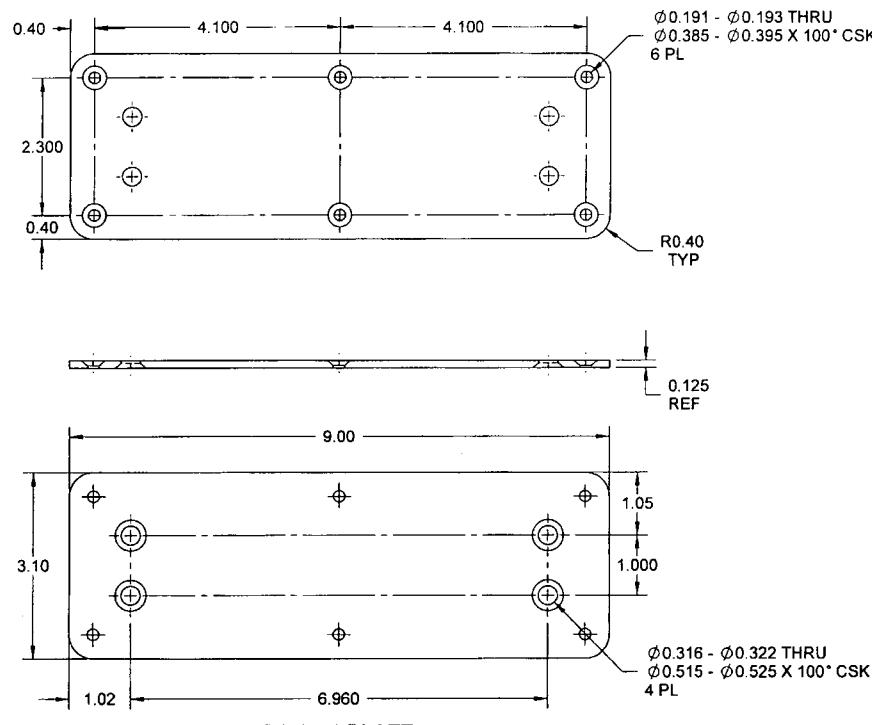
4

3

2

1

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		REV. A	
APPROVED		D3779	
DE APPR.		SHEET 2 OF 4	
DATE	08.04.21	TITLE	
		HANDLE ASSEMBLY, CABIN SLIDING DOOR	
		SCALE NTS	
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NOTES:

- 1) MATERIAL: -1 PLATE:  
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.125
- 3 PLATE:  
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-3" USING FINE POINT PERMANENT INK MARKER  
(DO NOT IDENTIFY -1 & -5)
- 7) WEIGHT: 0.14 lbs FOR -3.

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3779	
MFG. APPR.		REV. A	
APPROVED		SHEET 3 OF 4	
DE APPR.		TITLE HANDLE ASSEMBLY, CABIN SLIDING DOOR	
DATE	08.04.21	SCALE	NTS

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RELEASED  
08.05.26/10

